

Work Order ID 52773

Page 1

October 14, 2009 9:52:23 AM

Item ID: D3053-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 09/10/10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Draw Nbr	Revision Nbr
D3053	Rev B

100



Large Fab

0.00

09/10/23

Large Fab

Memo

0.00

1-Cut 5 D2235-3 FROM D3166-1 using DT8365 □2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

*-Cut ribs as per dwg
-Cut Mesh*

PD 09.10.20

110



Large Fab

0.00

Large Fab

Memo

0.00

1-Remove all markings from material □2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

PD 09.10.20

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

09/10/23

09/10/24

Pb →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: Large fab NCR: Yes No DQA: J Date: 09.11.06
 Resolution: Rework Disposition: Rework QA: N/C Closed: J Date: 09.11.17

NCR: 52773		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/09	#R 100	After welding, welder notices that he welds almost everything wrong. 4 out of 5 ribs are in the wrong location. Placed the jig on the opposite side.	J 09/10/09	Remove old welds if new - #2327-3 → B44274 Plug the off-set holes on the one side, & fill with weld & grind flush per spec 0001.	J 09/10/09	↓	J 09/10/09	S 09/10/09
		R6 he didn't take the time to Position the jig in the correct orientation. LOA.	J 09/10/09	- Drill the holes in the correct location in copper (site side) per the drawing. * Ensure no foreign objects. #2327-3 → B44274 B	J 09/10/09	S 09/10/09	J 09/10/09	S 09/10/09

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

2) S910027

140



DC

Document Control

DOCUMENT CONTROL

Memo

Take Traveller D205-541-043 to KP

0.00

N/A
Mo 10/27

150



Powdercoat

Powder Coating

1ST

Memo

START TIME: 1:00 pm OVEN TEMPERATURE:
1:30pm FINISH TIME: 400F

0.00

28 09/10/27

ZND START: 2:00 pm
Temp: 400°F
FIN: 2:30 pm

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Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160



QC3- Inspect Part Finish

0.00

BK 09-10-08



QC

Memo

0.00

Quality Control

170



Identify as per dwg & Stock Location: _____

0.00

POP
52772 0.00

Packaging

Memo

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

0.00

Picklist Print

Page 1
13

October 14, 2009 9:52:43 AM

Work Order ID: 52773



Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304EX0.75-16F



Purchased

No

100

sf

306.0011

50.5263

*3AD 09-10-16*

Expanded Metal Flat SS

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

MAT

306.0011065

110134

6.7

110629

14.41

111630

9.15

111956

0.000017

112147

54.8205895

112311

28.9205

112707

192

*8.00 → Scrap = 6.41**4 r 00**38.5263**← 96 →
6.41*

M304TS0.750W.065



Purchased

No

100

f

678.9022

45.6140



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

WA

678.9022

112398

678.9022

PD 09.10.20

Picklist Print

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October 14, 2009 9:52:43 AM

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Parent Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC



Manufactured

No

110

Each

11.0000

2.0000



Basket Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

50024

2

51870

6

② Oct 09, 10.22

Main Warehouse

WA

3

50986

3

D2327-3RevD



Manufactured

No

110

Each

48.0000

2.0000



Spacer Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48

44274

29

44365

9

51126

10

② Oct 09.10.20

Picklist Print

Page 3

October 14, 2009 9:52:43 AM

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Parent Item: D3053-042RevB



Parent Item Name: 212 Basket Base Assembly

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			110	Each	76.0000	2.0000			

Mounting Bracket

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

ST	13	
46086	2	
48428	1	
51120	10	

Main Warehouse

WA	63	
50872	14	
51745	49	

D3166-1RevA1



Manufactured

No

110 Each 22.0000 5.0000



Basket Hoop

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

WA	22	
51248	7	
51474	3	
51951	12	

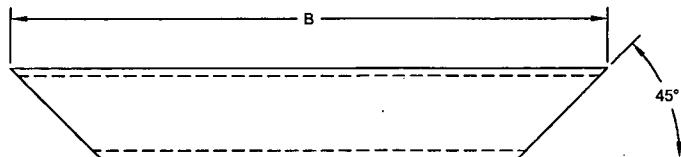
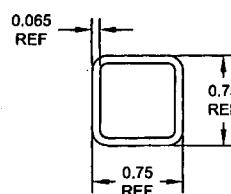
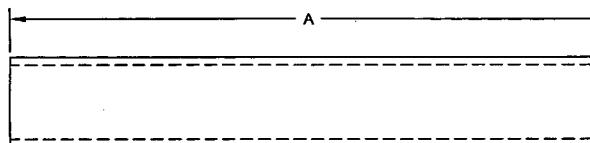
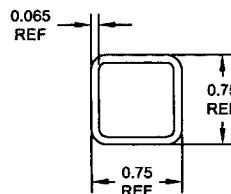
(2) CPC 09.10.22

P0 09.10.20

8 7 6 5 4 3 2 1

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



B

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

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 WORK ORDER
 NO. 32723
PL 09-10-14

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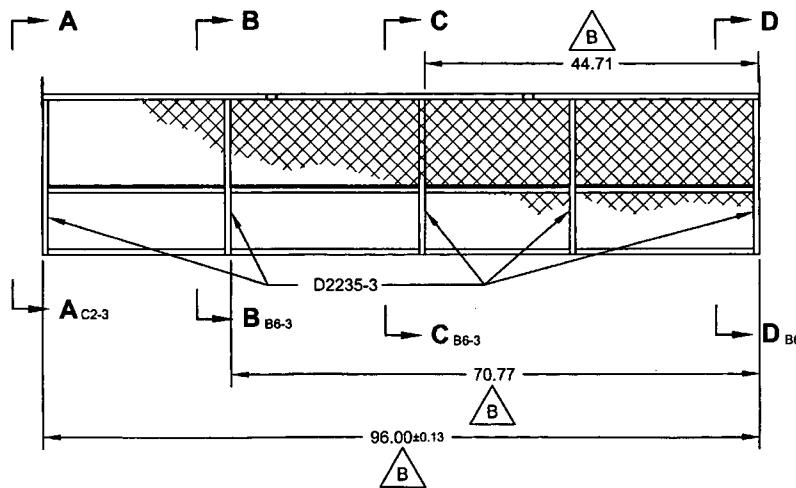
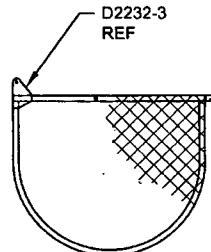
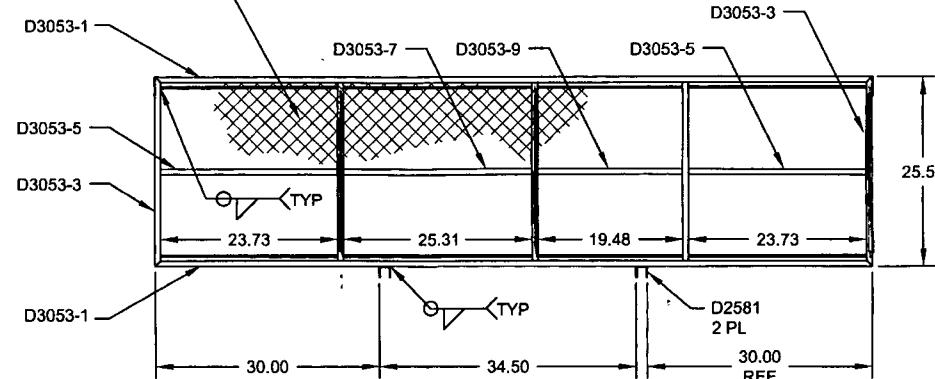
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION		
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	REV. B	
MFG. APPR.		DRAWING NO.	
APPROVED	AJ	D3053	SHEET 1 OF 3
DE APPR.		TITLE	SCALE
DATE	08.07.02	BASKET BASE ASSEMBLY (212)	NTS

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	C	D3053	SHEET 2 OF 3
APPROVED	D	TITLE	SCALE
DE APPR.	E	BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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09-28-21 MM

8 7 6 5 4 3 2 1

D

C

B

A

